

Work Order ID 165817

Wednesday, August 30, 2017 7:15:59 AM

Page 1

Item ID: D3043-041

Accept

Ship Sept. 18
165817
N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Weldment LH

Start Date: 8/30/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/13/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3043	Rev A

100

0.00

100

Large Fab

Large Fab

Memo

0.80

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting
table setup DT8185-G
2-Deburr and bevel ends for welding*x1 S.L 2017-8-30*

110

QC6- All purchased or subcontracted products

0.00

110

QC

Memo

0.00

Quality Control

AUG 30 2017**DAS
24
9-89**

120

0.00

120

Large Fab

Large Fab

Memo

0.99

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using
DT8802
AR AL ROD Batch: *M130150*
2-Grind Fwd End Cap weld flush*x1 S.L 2017-8-30*

Work Order ID 165817

Wednesday, August 30, 2017 7:15:59 AM

165817

Page 2

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment LH
Start Date: 8/30/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>1</u>	<u>1709-01</u>		DAS 9 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>0</u>	<u>1709-01</u>		DAS 9 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.31				<u>1</u>	<u>2</u>	<u>2017-09-01</u>	JSL DAS 19 9-89

Work Order ID 165817

Wednesday, August 30, 2017 7:15:59 AM

165817

Page 3

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment LH
 Start Date: 8/30/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/13/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Large Fab								
Large Fab	Memo	0.46							
Large Fab	1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: <u>M136159</u> 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.02							
Quality Control									

*1 S.L 2017-9-5

1 SEP 05 2017 DAS 24 9-89

1 SEP 05 2017 DAS 24 9-89

165817

Wednesday, August 30, 2017 7:15:59 AM

Item ID:	D3043-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Step Weldment LH				Stop	*NS2*
Start Date:	8/30/2017	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	9/13/2017	Req'd Qty:	1.00	*1*	Customer:	
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

Work Order ID 165817

Wednesday, August 30, 2017 7:15:59 AM

165817

Page 5

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment LH
Start Date: 8/30/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.01							
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.01							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.10							
Quality Control									

DAS
9
9-89SMB
17/9/20

17/9/22



SEP 21 2017

Picklist Print

Wednesday, August 30, 2017 7:15:56 AM

Page 1

Work Order ID: 165817

165817

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH

Start Date: 8/30/2017

Required Date: 9/13/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

207.0000

1

1

D2622-120C

Step Extrusion

**

x1 S.L 2017-8-30

Location

Loc Qty

Loc Code

WA003

207

162484

207

D2734

Manufactured

No

120

Each

59.0000

1

1

D2734

Step End Plate

**

x1 S.L 2017-9-5

Location

Loc Qty

Loc Code

WA003

59

161519

35

164510

24

D2734

Manufactured

No

160

Each

59.0000

1

1

D2734

Step End Plate

**

x1 S.L 2017-8-30

Location

Loc Qty

Loc Code

WA003

59

161519

35

164510

24

D3040-1

Manufactured

No

120

Each

6.0000

2

2

D3040-1

Mounting Lug

**

x1 S.L 2017-8-30

Location

Loc Qty

Loc Code

WA003

6

125837

6

Picklist Print

Wednesday, August 30, 2017 7:15:57 AM

Page 2

Work Order ID: 165817

165817

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH

Start Date: 8/30/2017

Required Date: 9/13/2017

Start Qty: 1.00

Required Qty: 1.00

D3040-3

Manufactured No

100

Each

22.0000

2

2

D3040-3

**

x2 S.L 2017-8-30

Mounting Lug

Location

Loc Qty

Loc Code

WA003

22

128957

20

83998

2



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*WFO
10/5/07*

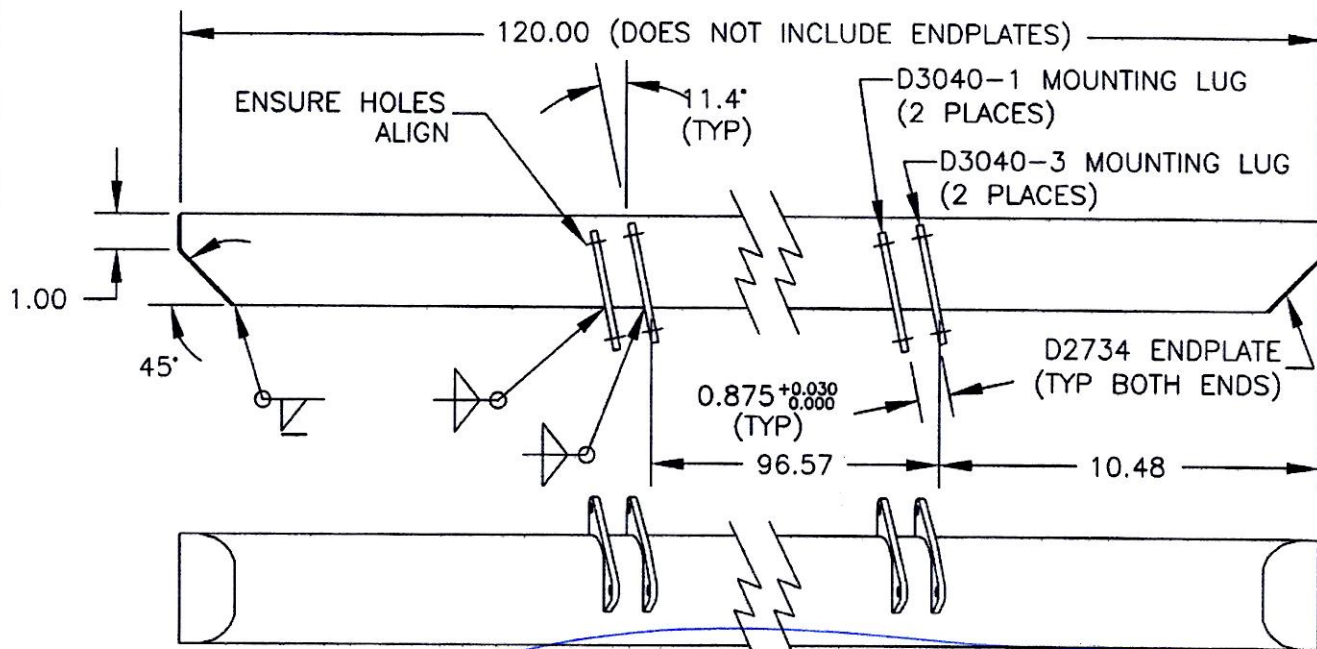
RELEASED
01.07.05

Copyright © 2001 by DART AEROSPACE USA, INC.

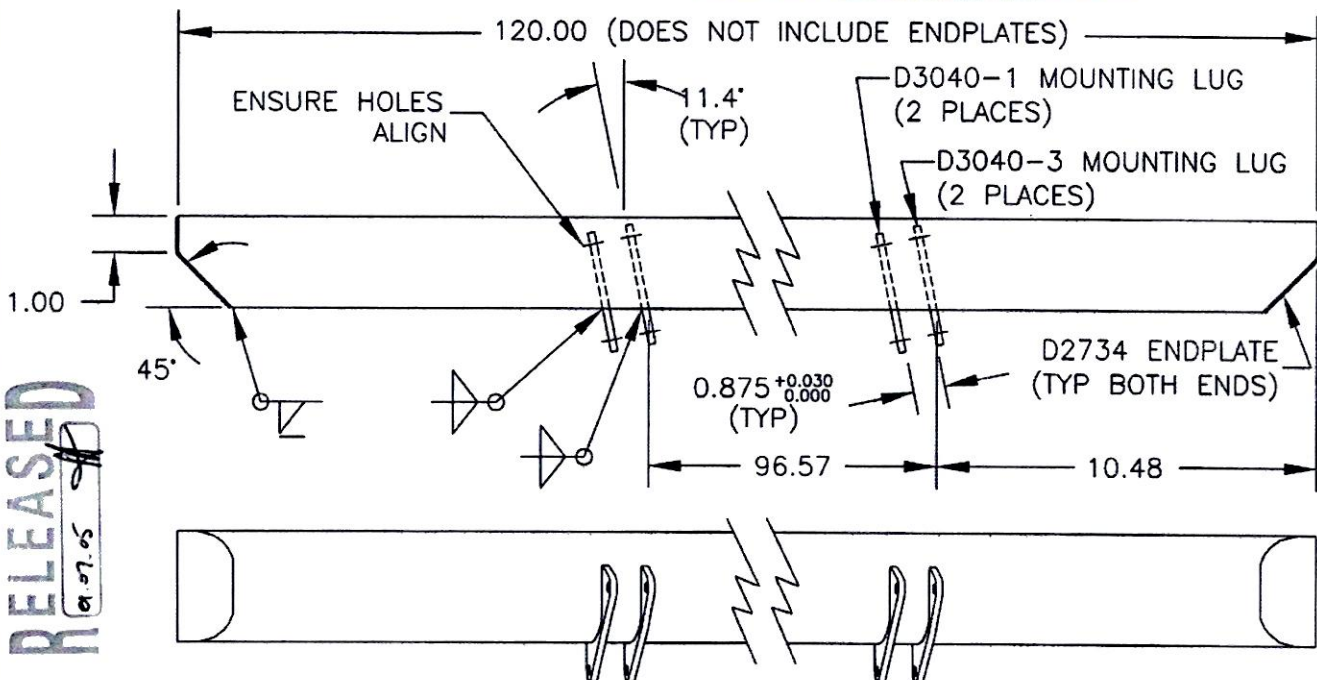
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT *



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED
01.07.05

Copyright © 2001 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.